

Date: Thursday, 7/19/2007 2:20:22 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	33629		
Estimate Number	12729		
P.O. Number	N/A	Part Number	D353539
This Issue	7/19/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3535 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	33440	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By		Due Date	8/3/2007
Comment	Est Rev:A New Issue 07-02-15 JLM	Qty:	20
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet



Comment: Qty.: 0.9986 sf(s)/Unit Total : 19.9710 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M105061

HB 07-07-21

2.0	WATER JET	.FLOW WATER JET
-----	-----------	-----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

20

2-Deburr if necessary

HB 07-07-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 07-07-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

20 07/07/03

20

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

FF 07-07-23

FF 07-07-24

20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:20:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33629

Part Number: D353539

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

en 07/07/2007 20

7.0 POWDER COATING

POWDER COATING



m 104846

20

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Be/m.d 07-07-25

8.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F2 07/07/25 20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



20x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16

m-f

07/07/25

10.0 QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

07/07/25

Job Completion



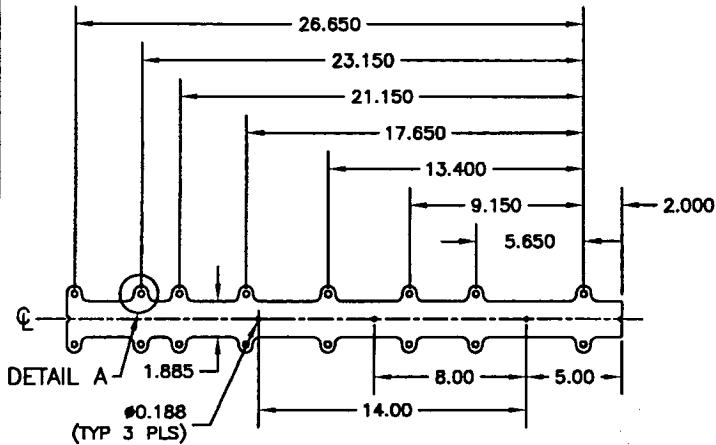
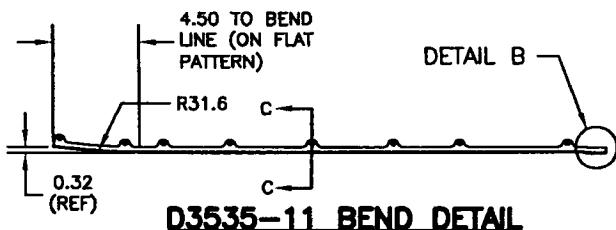
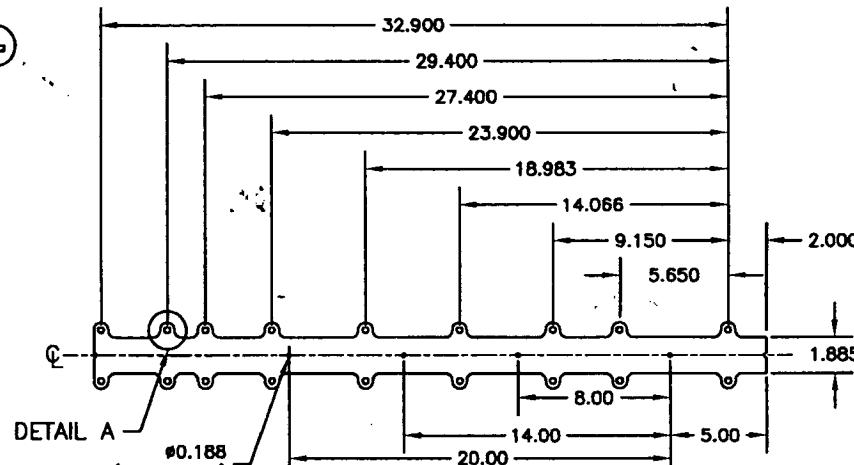
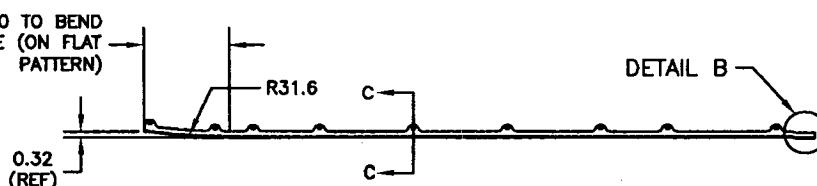
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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NO  
33629  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	P.H	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
TH	TH	D3535
07.04.17	06.10.25	WEARSHOE
A	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SHEET 1 OF 7
		SCALE 1:10

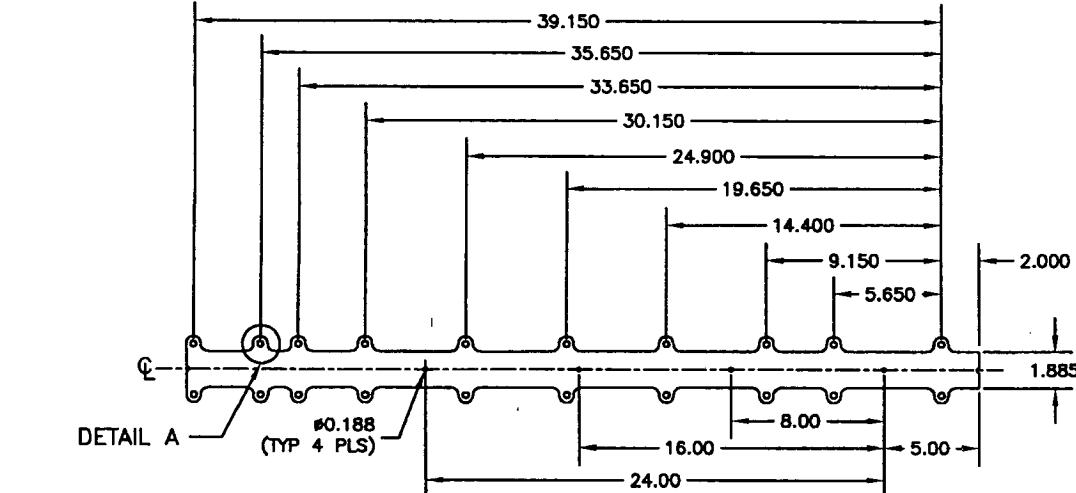
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57.04.24

**DART**

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CHECKED <i>ML</i>	APPROVED <i>ML</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7 SCALE 1:10

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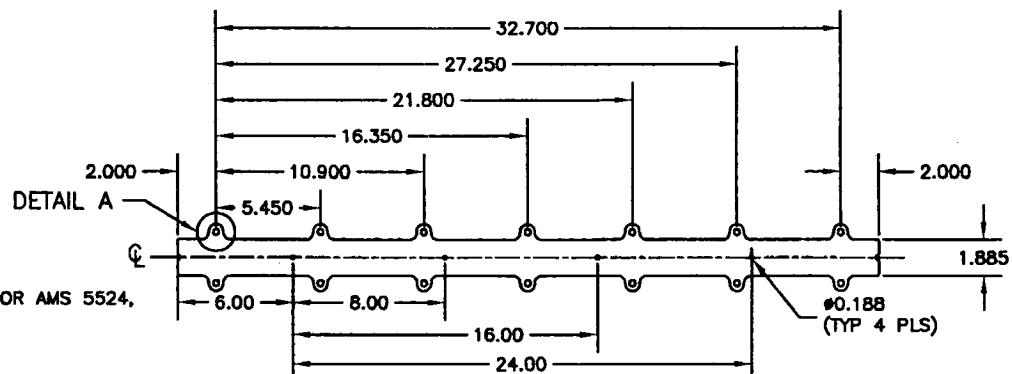
07.04.24

**D3535-15F FLAT PATTERN**

4.50 TO BEND LINE (ON FLAT PATTERN)  
R31.6  
0.32 (REF)

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WITHOUT NOTICE  
WORK ORDER #  
NO. 33629

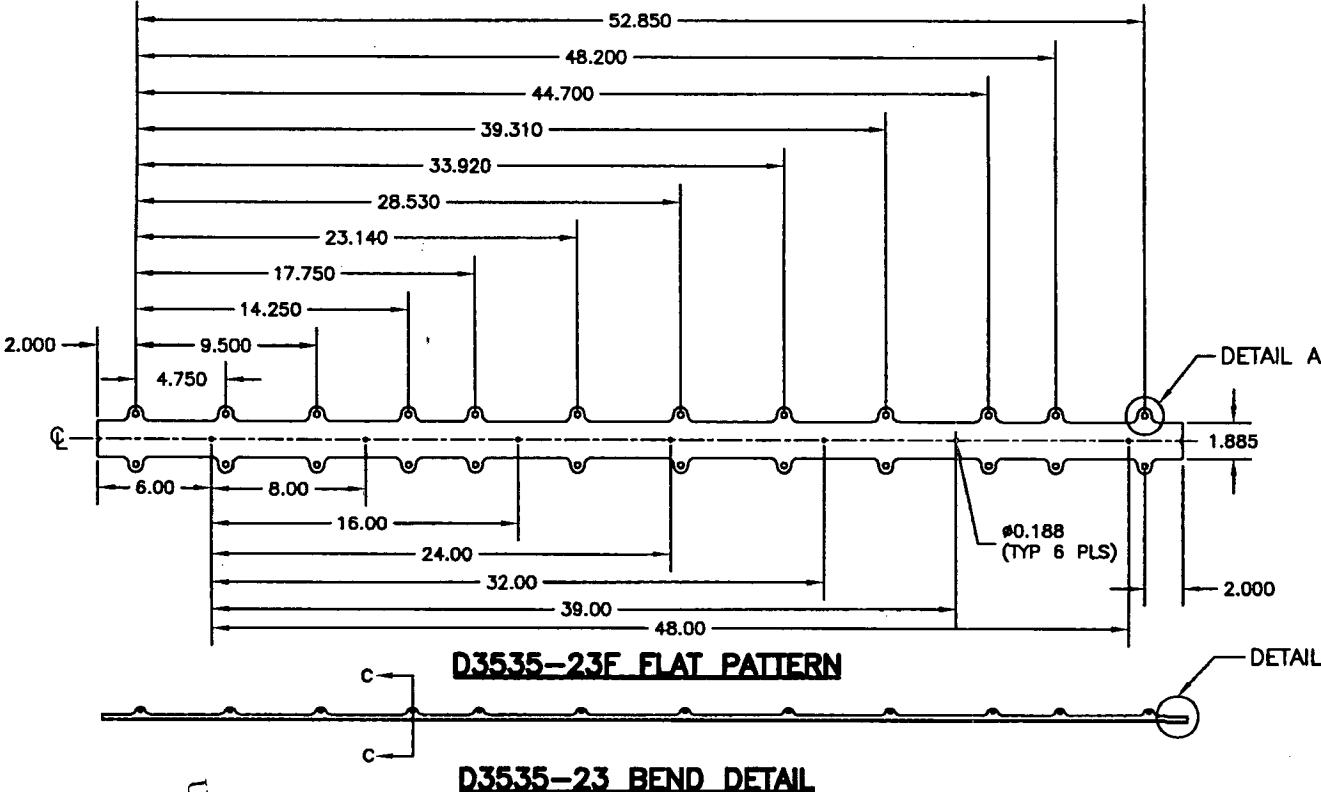
DETAIL B

**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

**DART**

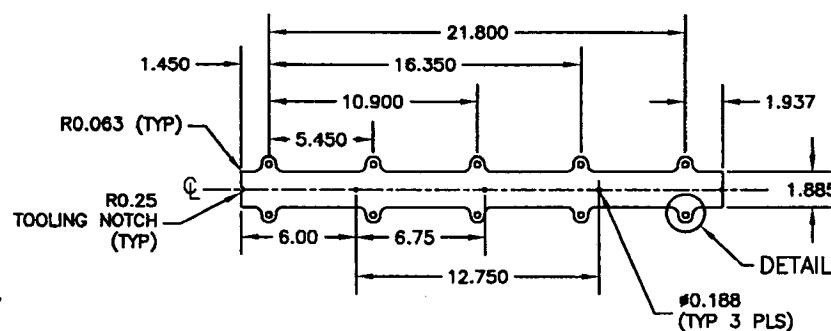
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DATE 07.04.17		TITLE WEARSHOE

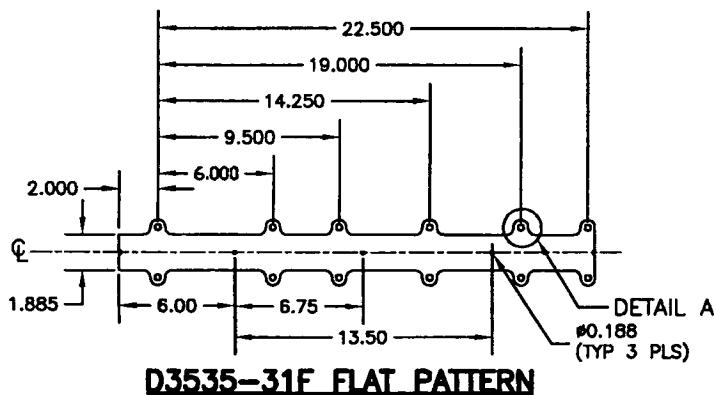
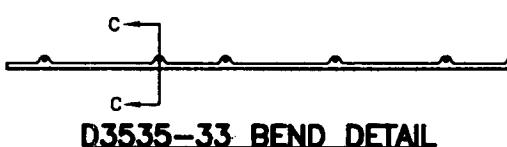
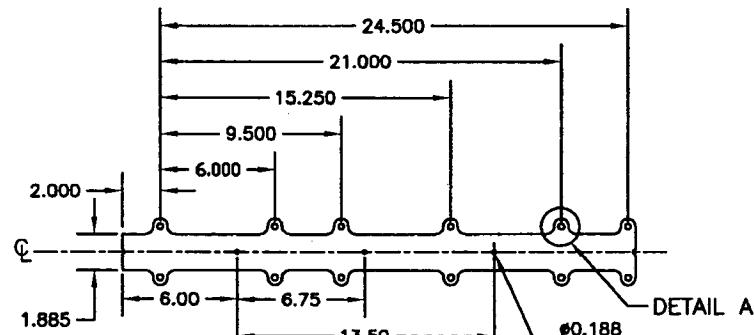
REV. B  
SHEET 3 OF 7  
SCALE  
1:10

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07.04.24

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WITHOUT NOTICE  
WORK ORDER  
NO. **33629**

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
  - 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
  - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
  - 8) SEE PAGE 7 FOR DETAILS AND SECTION



**DART**RELEASED  
07.04.17**D3535-31 BEND DETAIL****D3535-33 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

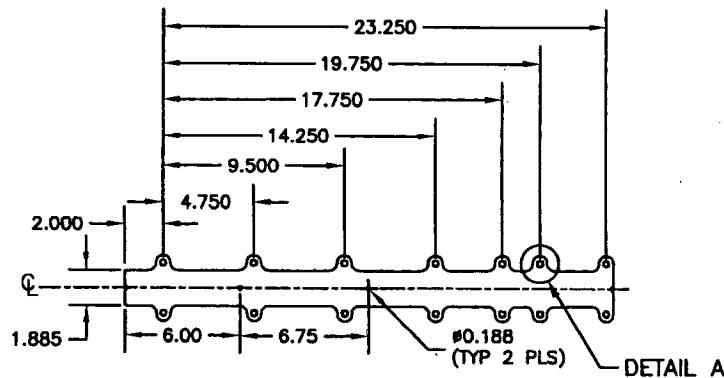
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WORK ORDER NO. 32629

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C.B	MH	DRAWING NO. D3535	SHEET 4 OF 7
CHECKED	APPROVED	DATE 07.04.17	SCALE 1:10

**DART**

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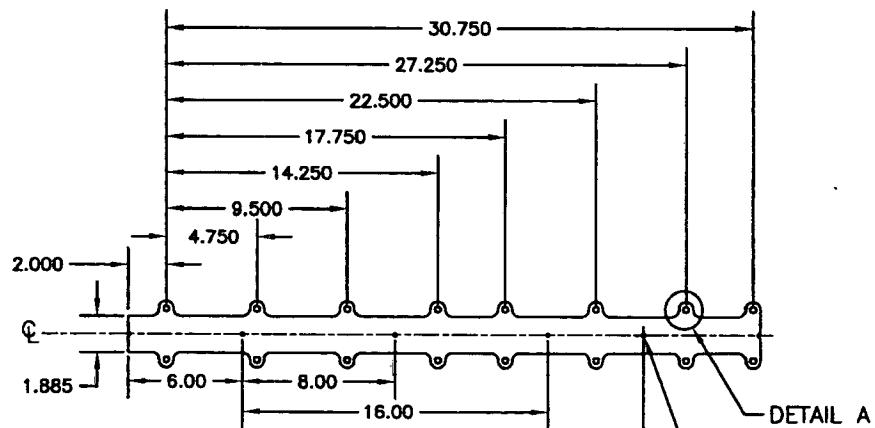
07.04.24

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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WORK ORDER  
NO. 233629

**NOTES**

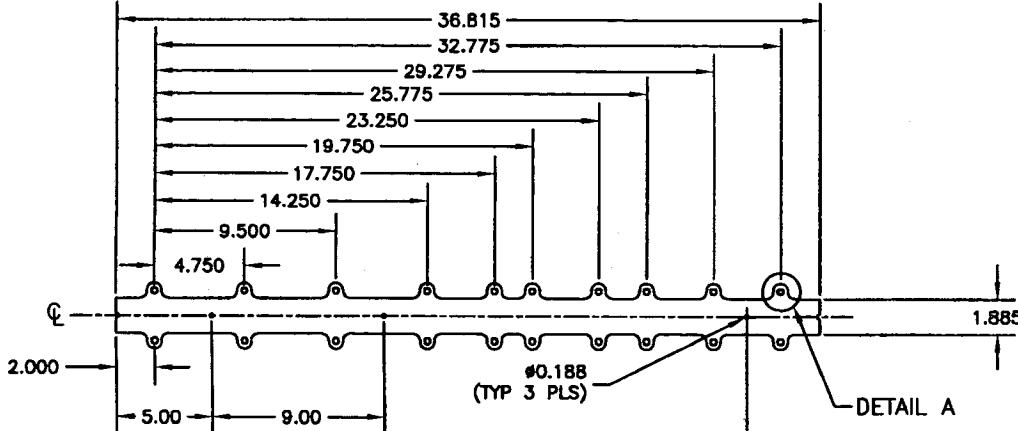
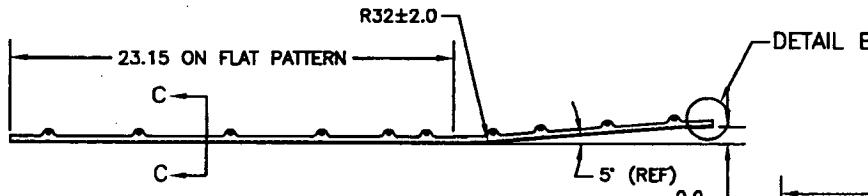
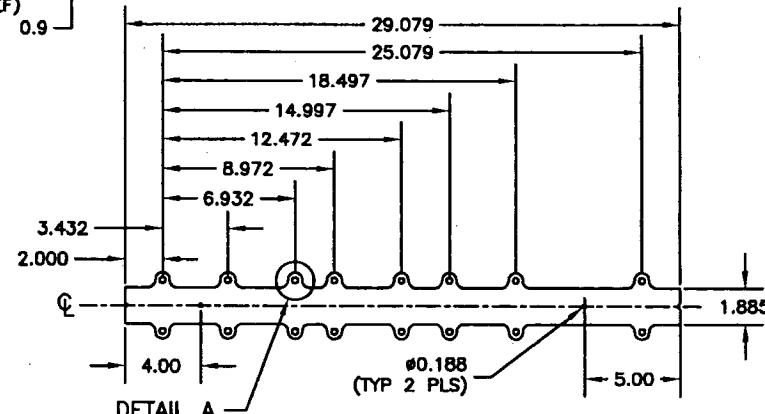
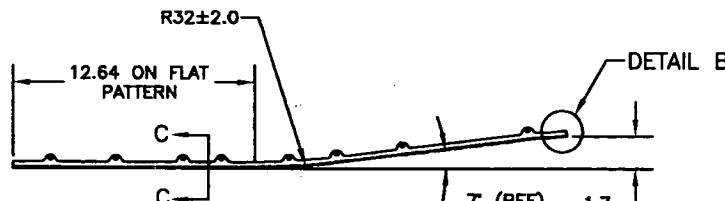
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER  
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PAINT MARKER
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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CHECKED <b>TH</b>	APPROVED <b>TH</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 5 OF 7 SCALE <b>1:10</b>

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>M</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>M</b>	APPROVED <b>M</b>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	SHEET 6 OF 7 SCALE 1:10

RELEASED  
07.04.24**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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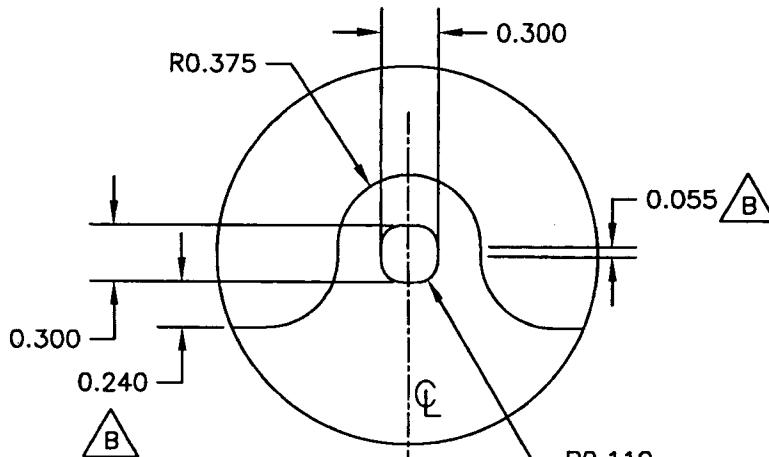
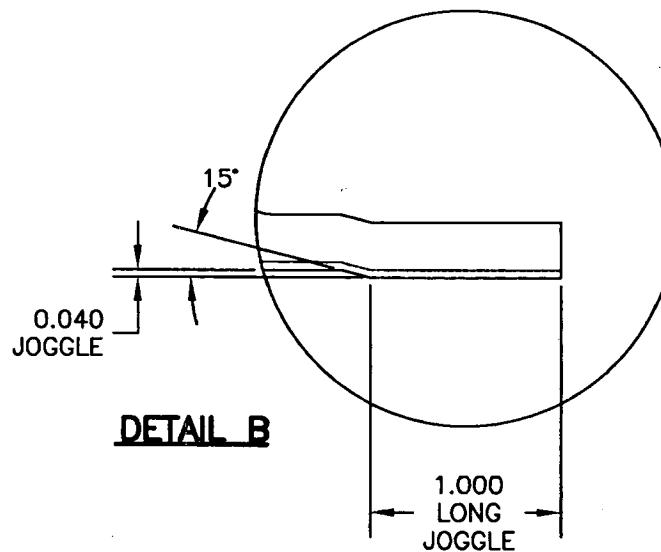
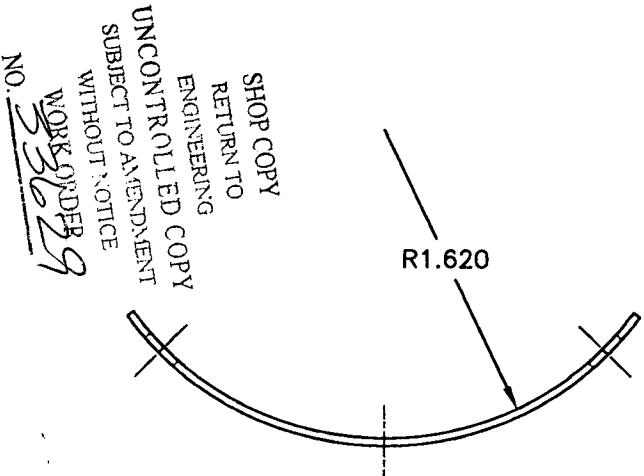
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WORK ORDERS  
NO. 3629

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
C-B	PH	PORT HADLOCK, WA	SHEET 7 OF 7
CHECKED	APPROVED	DRAWING NO. D3535	DATE 07.04.17
		TITLE WEARSHOE	SCALE 1:1

**DETAIL A****DETAIL B****SECTION C-C**

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WORK ORDER  
NO. 3629

DART AEROSPACE LTD	Work Order:	33629
Description: WENR Slot	Part Number:	D3535-39
Inspection Dwg:	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	GS	Prototype Approval:	
Date:	07-07-21	Date:	07/07/23	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

